

55551-5

Work Order ID

January 20, 2010 11:04:34 AM

Page 1

Item ID: D2492

Accept

Setup Start

Revision ID:

Stop

Item Name: Patient Stop

Start Date: 1/20/10

Start Qty: 10.00

Cust Item ID:

Required Date: 1/29/10

Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2492

Rev F

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2492
Debur if necessary

Dwg Rev. F

Prog Rev. f 2-

10-1-21

5

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-1-21

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

5 10/01/02

111

Ph

Work Order ID 55551

January 20, 2010 11:04:34 AM

Item ID: D2492
Revision ID:
Item Name: Patient Stop

Start Date: 1/20/10 Start Qty: 10.00
Required Date: 1/29/10 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: Date:
QC: Date:

Sequence ID/
Work Center ID

Operation
Description

130
Brake NC
Brake NC

NC BRAKE

Memo
Deburr Form using Jig D12492B3

140
QC
Quality Control

QC5- Inspect part completeness to step on W/O

Memo

150
HandFinish
Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo



Page 2

Accept



Setup Start



Stop



Cust Item ID:
Customer:

Run Start



Stop



Tooling: Date:
SPC (Y/N): Date:

Set Up/
Run Hours
0.00

Draw
Number
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

SB 11/04/28

①

0.00

Subtotal

@

0.00

0.00

0.00

1 of 20 11/05/28

135

Large Feb

N/A

11/04/28

PTD

Work Order ID 55551

January 20, 2010 11:04:35 AM



Page 3

Item ID: D2492

Accept



Setup Start



Revision ID:

Item Name: Patient Stop

Stop



Start Date: 1/20/10 Start Qty: 10.00



Cust Item ID:

Required Date: 1/29/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1. BR 11-5-3

170

White Gloss(Ref:4,3,5,1) per QSI005 4 3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME

FINISH TIME:

OVEN TEMPERATURE:

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

①x ~~φ~~ m-l 11/05/09

1 ~~φ~~ 11/05/09

M116964

320 OF
8:40

9:10

Work Order ID 55551

January 20, 2010 11:04:35 AM

Page 4

Item ID: D2492

Revision ID:

Item Name: Patient Stop

Start Date: 1/20/10 Start Qty: 10.00

Required Date: 1/29/10 Req'd Qty: 10.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

190



Packaging

Packaging

Operation
Description

Identify as per dwg & Stock Location: 6A

Memo

w/o
69080

Set Up/
Run Hours

0.00

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

11/05/09

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

11/5/10

11-05-4
①

Picklist Print

January 20, 2010 11:04:33 AM

Page 1

Work Order ID: 55551



Parent Item: D2492



Parent Item Name: Patient Stop

Start Date: 1/20/10

Required Date: 1/29/10

Comments: IPP E 00.06.26 Removed P/O for powder coat EC
 IPP Rev:F Now 6061-T6 06-06-23 JLM
 IPP Rev:G now water jet 07-12-11 DD

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last
M646PT6S.080		Purchased	No		

Route	Unit of	Qty on	Remaining	Qty	Date	Status
100	sf	178.9597	19.1884			



6061-T6 .080 Sheet



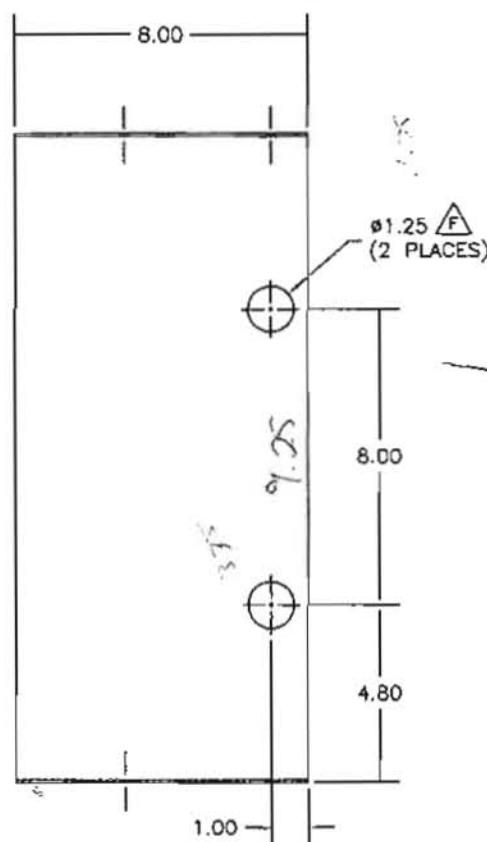
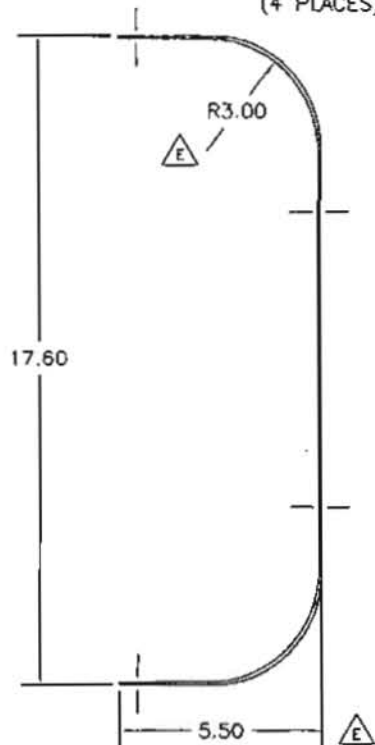
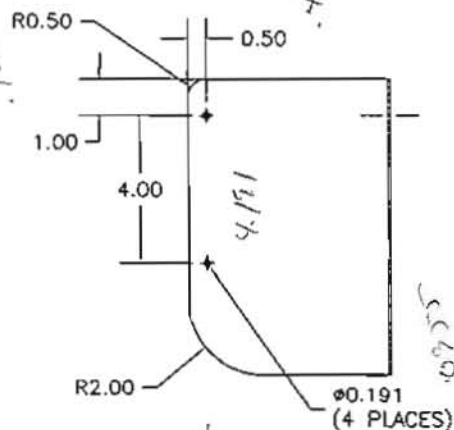
1810-1-21

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
MAT	178.95967	
110630	35.0136	
112141	0.86727	
112763	6.85	
113438	136.2288	

(18)
 113438

DART

DESIGN KE	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED <i>[Signature]</i>	DRAWING NO. D2492	REV. F SHEET 1 OF 1
DATE 06.09.14		TITLE PATIENT STOP	SCALE 1:5
A	95.10.24	NEW ISSUE	
B	96.02.28	MINOR CHANGES	
C	97.07.14	CHANGED MATERIAL AND FINISH	
D	98.05.11	R4.00 WAS R2.00 ADDED 8" WIDTH DIMENSION	
E	06.05.30	ADD 6061-T6 MATERIAL, R3.0 WAS R4.00, 5.50 WAS 6.00	
F	06.09.14	Ø1.25 WAS Ø1.020	

**D2492 PATIENT STOP**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

RELEASED06.09.14 *[Signature]*

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Under Review Notification

Raised By: C Provencal

Date: 10.05.20

Product #: D350-616

Product Name: Litter Kit

Drawing/Kit Number	Drawing/Kit Description	Quantity on Hand (Stock)	Quantity on Order (Production)	Quantity Allocated (Customer Order)	HOLD SHIPMENT	Red Tag/Quarantine Stock	Advise customers	Stop Production	Re-Work Stock	IPP Under Review	Blue File Under Review	ECN #	Instructions
D2492	Patient Stop				N	Y	N	Y	Y	Y	Y	10-577	Quarantine stock, rework per instructions
D2493	Patient Stop Assembly				N	Y	N	Y	Y	Y	Y	10-577	below, OK to ship after rework.
D350-616-011	Full Litter Kit				N	Y	N	N	Y	Y	Y	10-577	Get ENG sign off to produce more, with lower hole removed.

Description of Issue:

- Location of holes in litter kit for installation of patient stop has no consistency between batches.
- Lower hole from D2492 Patient Stop will be removed. As part of assembling litter kit, patient stop will be drilled to match litter. For replacement parts, customer will transfer drill patient stop to fit litter.
- Rework existing stock of D2492/D2493 patient stops to remove lower hole. Any patient stops already in kits that fit their litter are OK as-is.
- Ensure for any D315-616-011 in stock that the patient stop fits the litter.

Distribution:

General Manager
Production Manager
Director Quality Assurance
Design Manager
Chief Engineer

Production Engineering Coordinators
Quality Assurance Coordinator
Quality Control Coordinator
Order Processing
Customer Technical Support

Engineering Project Managers
Engineering Clerk
Marketing